



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Alperut
003579

D412-630-033
Job Sheet 175939



Part No: D412-630-033

Job Qty: 2 ea

Part Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Due Date: 6/29/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV O IPP Rev:A New Issue 06-11-08 JLM IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D 13.06.07 PER CHG004 DD vef:JLM IPP REV:E
16.06.23 AS PER IIN REV.O DD VERF:JLM

Ship Via:

MAY 30 2018

Bill of Materials

MAY 30 2018

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Small Fab-4		
110	Small Fab	2 pcs	6/29/18	6/29/18	0.00	0.88	Small Fab-6		<i>DAS</i>
120	QC	2 pcs	6/29/18	6/29/18	0.00	0.00	QC5		<i>38</i>
130	Packaging	2 pcs	6/29/18	6/29/18	0.00	0.00	Packaging1-4		<i>JUN 18 2018</i>
140	QC	2 pcs	6/29/18	6/29/18	0.00	0.00	QC4		
145	DC	2 pcs	6/29/18	6/29/18	0.00	0.00	DC		
150	Packaging	2 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-2		<i>DAS</i>
160	QC21-FG	2 Ea	6/29/18	6/29/18	0.00	0.00	QC21		<i>21 JUN 21 2018</i>

Part Op 110 - Assemble as per dwg D412-630 p.14 Coat all hardware with LPS3 rust inhibitor A/R LPS3 batch: *123777*
Descriptions: COAT exposed HARDWARE WITH LPS PROCYON . A/R LPS PROCYON BATCH: *4132690*
145 - Photocopy bluefile & create labels per PPP D412-630-033 CHG005
150 - Identify and pack for shipping as per PPP D412-630-033

F9072



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Container No: S080099



Part: D412-630-033

Job No: 175939

Serial No/Batch: S080099

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/12/18

2018
15
30

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN310C8	Nut	4 Ea (2 ea)	90-Start up Operation	5006250
AN3C21A	Bolt	2 Ea (1 ea)	90-Start up Operation	5006260
AN8C16	Bolt	4 Ea (2 ea)	90-Start up Operation	FM137706
D2012-107	Clevis	2 Ea (1 ea)	90-Start up Operation	5040916-1
D2803-041	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5044581
D2804-041	Bracket Assembly	2 Ea (1 ea)	90-Start up Operation	5044593
D2807-041	Prop Assembly	4 Ea (2 ea)	90-Start up Operation	5044602
D2813	Washer	4 Ea (2 ea)	90-Start up Operation	5044602
D3395-1	Bushing	8 Ea (4 ea)	90-Start up Operation	5044602
D3562-041	Step Weldment	2 Ea (1 ea)	90-Start up Operation	5044602
D3672-15	Phenolic Washer	10 Ea (5 ea)	90-Start up Operation	5064650
D3672-19	Phenolic Washer	8 Ea (4 ea)	90-Start up Operation	5042894
D3672-7	Washer, Phenolic	8 Ea (4 ea)	90-Start up Operation	7148075
MS21043-3	Nut	8 Ea (4 ea)	90-Start up Operation	5034915
MS24665-302	Cotter Pin	4 Ea (2 ea)	90-Start up Operation	FM135672-1
MS24693-C280	Screw	4 Ea (2 ea)	90-Start up Operation	FM137597
MS24693-C285	Screw	2 Ea (1 ea)	90-Start up Operation	FM135200-30
AN44C7A	Eyebolt	2 Ea (1 ea)	130-Packaging	FM138209-80
AN4C10A	Bolt	2 Ea (1 ea)	130-Packaging	FM136044-0
AN4C15A	Bolt	4 Ea (2 ea)	130-Packaging	5044216
AN4C6A	Bolt	2 Ea (1 ea)	130-Packaging	5022515
AN5C15A	Bolt	4 Ea (2 ea)	130-Packaging	FM136089
D2806-1	Bushing	4 Ea (2 ea)	130-Packaging	5034016
D2806-3	Bushing	4 Ea (2 ea)	130-Packaging	5034003
D2810-5	Strut	2 Ea (1 ea)	130-Packaging	5061377
D3396-1	Spacer	4 Ea (2 ea)	130-Packaging	5063394
D3672-17	Phenolic Washer	14 Ea (7 ea)	130-Packaging	7150866
D3672-5	Washer, Phenolic	14 Ea (7 ea)	130-Packaging	750354
MS21043-4	Nut	8 Ea (4 ea)	130-Packaging	5062296
MS21043-5	Nut	6 Ea (3 ea)	130-Packaging	5024440

003916

5044602
5044602
5025808

515741

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN310C8	4	32	0
	AN3C21A	2	29	0
	AN8C16	4	27	0
	D2012-107	2	49	0
	D2803-041	2	6	0
	D2804-041	2	6	0
	D2807-041	4	20	0
	D2813	4	30	0
	D3395-1	8	70	0
	D3562-041	2	2	0
	D3672-15	10	534	0
	D3672-19	8	120	0
	D3672-7	8	1,214	0
	MS21043-3	8	1,075	0
	MS24665-302	4	41	0
	MS24693-C280	4	84	0
	MS24693-C285	2	13	0
130-Packaging	AN44C7A	2	12	0
	AN4C10A	2	15	0
	AN4C15A	4	48	0
	AN4C6A	2	375	0
	AN5C15A	4	28	0
	D2806-1	4	9	0
	D2806-3	4	17	0
	D2810-5	2	12	0
	D3396-1	4	41	0
	D3672-17	14	102	0
	D3672-5	14	1,461	0
	MS21043-4	8	916	0
	MS21043-5	6	112	0
Part Specifications				
Specifications could not be found.				

Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)

REFERENCE ONLY

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Revision: 0
Date: 16.03.18

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Description: HELI-ACCESS STEP, LH/RH (FOLDING)

[illegible]